

# Work Order ID 62248

Wednesday, September 22, 2010 3:39:42 PM



Page 1

Item ID: D3201-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 9/22/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 9/30/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date: 10-9-22

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3201

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3201

☐ Dwg Rev:

B

☐ Prog Rev:

B

☐ 2-

Deburr if necessary

B10-9-28

(14)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-9-28

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/10/22

(14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 62248**

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Page 2

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Start Date: 9/22/2010 Start Qty: 10.00

Required Date: 9/30/2010 Req'd Qty: 10.00

Reference:




Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Small Fab	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Debur Stack								
140  HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00							
Hand Finishing	Memo	0.00							
150  QC	QC3- Inspect Part Finish	0.00							
Quality Control	Memo	0.00							

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR.#: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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Page 3

Item ID: D3201-1

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Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 9/22/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 9/30/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Identify as per dwg & Stock Location: 40

0.00



Packaging

Memo

0.00

Packaging

10/9/29 SP (19x)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/30 JF  
mf  
10-9-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, September 22, 2010 3:39:46 PM

Page 1

Work Order ID: 62248

Parent Item: D3201-1

Parent Item Name: Doubler




Start Date: 9/22/2010

Required Date: 9/30/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A Removed from 9 Digit 06-01-25 JLM  
IPP Rev:B Now on Waterjet 06-08-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040 		Purchased	No			100	sf	339.5400	0.276	2.905263	3.9	1810-9-28	

2024-T3 .040 sheet

Location

Loc Qty

Loc Code

MAT	88.1	
114415	88.1	
MAT22	251.44	
110305	23.13	
111786	13.76	
112291	28.25	
112331	52	
113162	134.3	

1144.5

(14)

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W/O:		WORK ORDER CHANGES					
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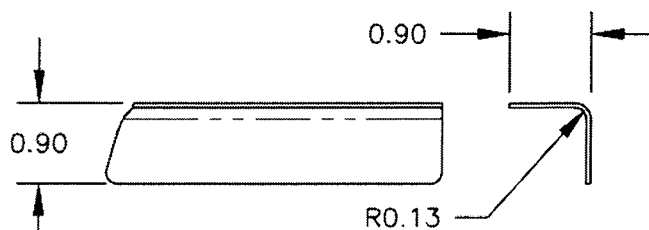
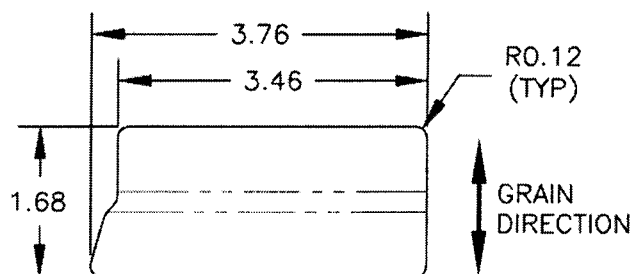
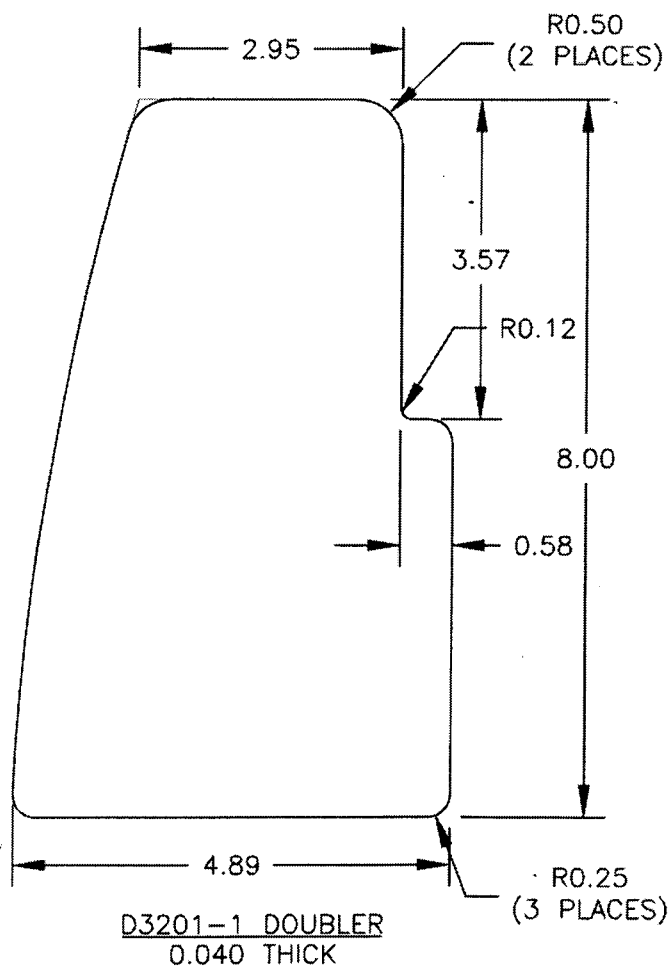
**NOTE:** Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD	
	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3201	SHEET 1 OF 1
DATE	TITLE		SCALE
03.11.03	DOUBLER		1:2
A	03.08.07	NEW ISSUE	
B	03.11.03	MODIFY D3201-1, ADD D3201-3/-4	

RELEASED  
03.11.14

SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 42248 P/O 9-23



D3201-1/-3/-4 DOUBLER

- 1) MACHINE PARTS PER DWG FILE "D3201-B1.DWG"
- 2) MATERIAL: 2024-T3 ALUMINUM SHEET (QQ-A-250/4)  
(REF. DART SPEC M2024T3S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES

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**Dart Aerospace Ltd**

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